

Date: Thursday, 5/25/2006 11:32:40 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG BRACKET
Job Number : 27196	
Estimate Number : 10733	
P.O. Number : N/A	Part Number : D30461
This Issue : 5/25/2006 S.O. No. : N/A	Drawing Number : D3046 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : 27196	Material : N/A
Written By : SEE COMMENT REBOW	Due Date : 6/1/2006
Checked & Approved By : SEE ABOVE USER & DATE	Qty: 22 Um: Each
Comment : Est A 01.08.27 New Issue SM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S12GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 0.1260 sf(s)/Unit Total : 1.5120 sf(s)

1010/1025/A21/6aA SHEET

Batch: M101094

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3046

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

SAD 06/05/26

22

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06/05/26

22

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

ED 06/05/29

22

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

Tumble & deburr

Bend as per dwg D3046

SAD 06/05/30

22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/05/21

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 5/25/2006 11:32:40 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 27196

Part Number: D30461

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ep 06/01/30 22

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/05/31 22

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/31 22

Job Completion



6.1 Powder Coat Gloss white, DL 06/05/31

6.2 QC3. Inspect powder coat finish SB 06/05/31 22

u 06/05/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/23/2006 8:32:03 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG BRACKET
 Job Number : 27196
 Estimate Number : 10733
 P.O. Number :
 This Issue : 5/23/2006 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : PURCHASED PARTS
 Previous Run : 24715
 Written By :
 Checked & Approved By : *06.05.23*
 Comment : Est A 01.08.27 New Issue SM

Part Number : D30461
 Drawing Number : D3046 REV A
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 6/2/2006 Qty: 12 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: _____

Laser cut per Dwg D3046

Material: ASTM A36 / A366 / A569 / A570 or AISI 1010 - 1025 Steel 0.100" thick

Mechanical prop.: UTS = Min.42ksi YTS = Min.28ksi

Material release note required

water Jet

2.0 D30461E Lug Bracket-Flat



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Lug Bracket

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

NA.

4.0 QC2 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2658T1

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Tumble & deburr

Bend as per dwg D3046

5/23 06/05/30

04.1 QC8.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/23/2006 8:32:03 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 27196

Part Number: D30461

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

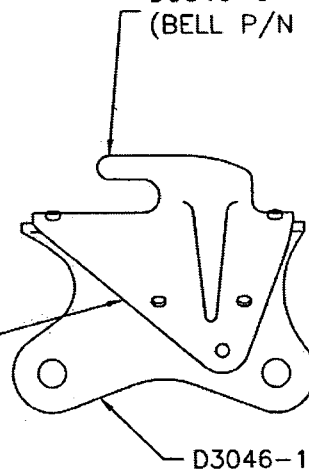
QA: N/C Closed: _____ Date: _____

DART



DESIGN	<i>[Signature]</i>	DRAWN BY	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3046
DATE	01.08.23	TITLE	LUG BRACKET	REV. A SHEET 1 OF 2
A	01.08.23	NEW ISSUE		SCALE 1:2

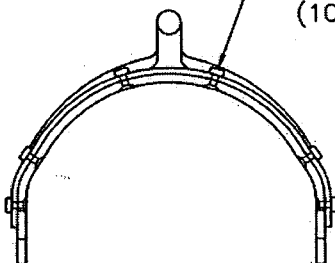
D3046-3
(BELL P/N 206-052-106-1)



D3046-1

CENTER D3046-3
ON D3046-1

TRANSFER DRILL $\phi 0.156$ HOLES
FROM D3046-3 TO D3046-1.
C'SINK $\phi 0.286 \times 100^\circ$
D3046-1 INSIDE BORE.
ASSEMBLE USING MS20426AD5-7
RIVETS.
(10 PLACES)



D3046-041 LUG BRACKET ASSEMBLY

NOTES:

- 1) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
POWDER COAT BOTH PARTS SEPARATELY BEFORE ASSEMBLY.
RE-POWDER AFTER ASSEMBLY.
- 2) REMOVE ALL PAINT/SEALANT FROM D3046-3 BEFORE POWDER COATING.

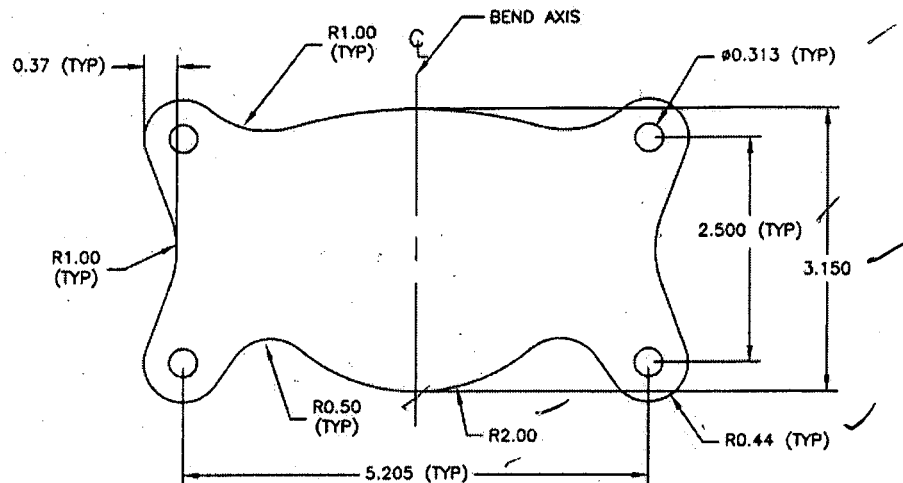
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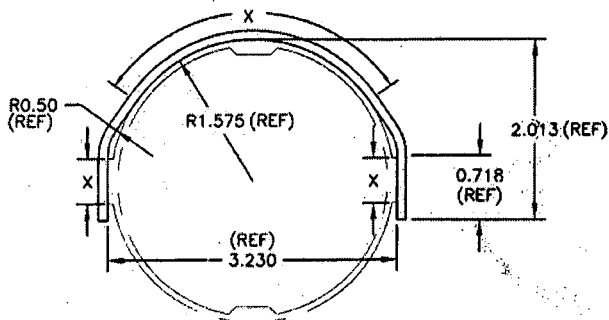
WORK ORDER
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DART

DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3046	REV. A SHEET 2 OF 2
DATE 01.08.23		TITLE LUG BRACKET	SCALE 1:2



D3046-11 FLAT PATTERN
SYMMETRICAL ABOUT CENTRE-LINES (C)



D3046-1
(MAKE FROM D3046-11)

D3046-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE
OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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